

Work Order ID 56914

March 12, 2010 1:29:01 PM



Page 1

Item ID: D3706-5

Accept



Setup Start



Revision ID:

Item Name: Pin

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: 14

Date: 10-3-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3706

Rev A

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA756 Rev: _____ & Dwg D3706 Rev: A □2- SL 10/03/22

(10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

SL 10/03/22

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

SL 10/03/22

QC

Memo

0.00

Quality Control

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56914

March 12, 2010 1:29:01 PM



Page 2

Item ID: D3706-5

Accept



Setup Start



Revision ID:

Item Name: Pin

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Bend as per dwg D3706	0.00 0.00	SD 10/04/21			_____	_____	_____	Ph-7
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S.060422			(X)	_____	_____	_____
150 Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo 1- drill hole as per dwg D3706	0.00 0.00				_____	_____	_____	_____

N/A 4/10/03-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3706-5 PAR #: Fault Category: Small Pals NCR: Yes No DQA: Date: 10/04/27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 10/04/27

NCR: <u>56914</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/31	130	5 pieces broke while Bending the 1/6" Rad. R.C. process / <u>10/24/27</u> <u>1st time</u> <u>5 broke out of batch!?</u>	<u> </u>	Scrap + destroy Qty x5 Material certs were reviewed and are correct. <u> </u>	<u> </u> <u>10/04/27</u>	<u> </u> <u>10/04/27</u>	<u> </u> <u>10/04/27</u>	<u> </u> <u>10/04/31</u>

NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 31, 2010 11:24:02 AM

Page 1

Work Order ID: 56914



Parent Item: D3706-5



Parent Item Name: Pin

Start Date: 12/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:A New Issue 08-05-30 EC Verified By:DD

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R0.313 		Purchased	No				f	31.6425	0.4000			
303 ROUND BAR .313												

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT028	31.6425	
108220	3.24	
110551	3.3825	
111787	25.02	

-500 JL 10/03/22

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

Prototype

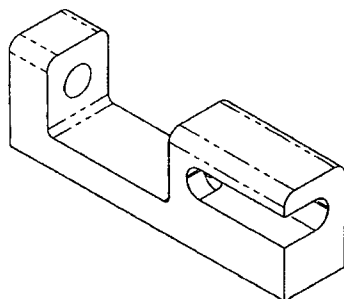
[illegible]

Measured by:	SL
Date:	10/03/21

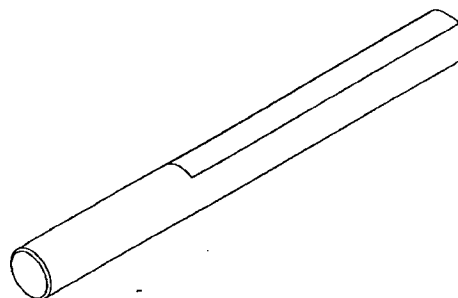
Audited by:	AF
Date:	10/03/22

Prototype Approval:	N/A
Date:	N/A

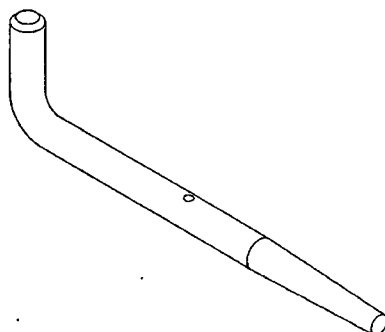
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3706-1 LOCK BRACKET



D3706-3 GUIDE



D3706-5 PIN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 56914

2110-3-15

RELEASED
09/02/05 MTD

A	NEW ISSUE	MB	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.26		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3706	REV. A SHEET 1 OF 4
TITLE INSTRUMENT PANEL LOCK	SCALE NTS
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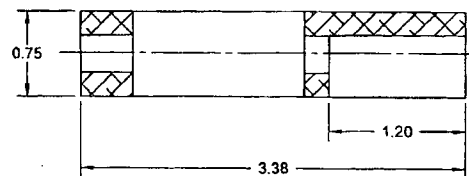
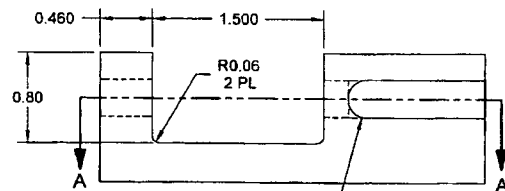
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

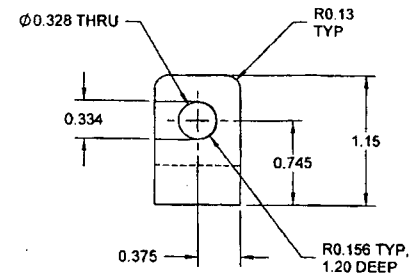
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A

D3706-1 LOCK BRACKET



w/o 56914

RELEASED
8/12/05 MFB

D3706-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED	<i>15</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>15</i>	D3706	SHEET 2 OF 4
APPROVED	<i>15</i>	TITLE	SCALE
DE APPR.	<i>15</i>	INSTRUMENT PANEL LOCK	NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Ø0.50



0.450

3.38

0.03 X 45°
TYP

5.25

D3706-3 GUIDE

w/o 56914

RELEASED
09/02/05

D3706-3 GUIDE NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) ALUMINUM ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6R0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED	<i>MB</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MB</i>	D3706	SHEET 3 OF 4
APPROVED	<i>MB</i>	TITLE	SCALE
DE APPR.	<i>MB</i>	INSTRUMENT PANEL LOCK	
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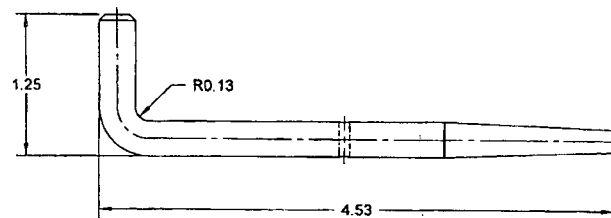
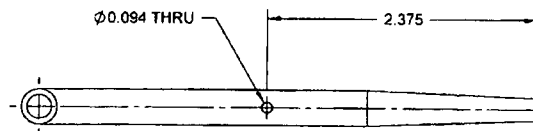
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

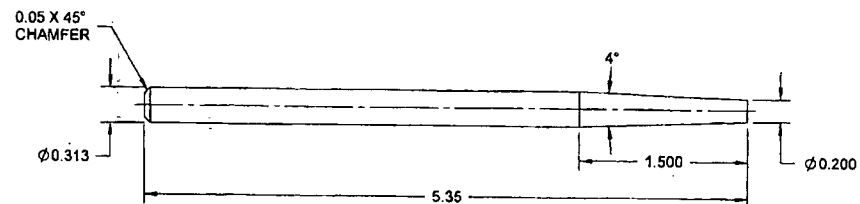
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3706-5 PIN
(MAKE FROM D3706-SF)



D3706-SF PIN

W/0 56814

RELEASED
09/12/05

D3706-5 NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
(REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3706	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL LOCK	NTS
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2.324

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Supplier: magnus

Dart P/O: 7927

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☒
Shipment Complete: Yes ☐ No ☒ N/A ☐
QOS Inspection ☐ N/A ☒
Work Order 0910189 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M174B02000000		24	0	0	24	
M6048763070000		120	0	0	120	
M6061765050		192	0	0	192	

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 09.01.19
Date
Received/Costing 309992
Initial JW

Location _____

H:\FORMS\Purchasing\approved purch\RECREPORT.R v D

REFERENCE ONLY

L019382 10 PC/840 LB

RECEIVED JAN 22 2009

01/19/09 15:29:39

Merchandise:	2,455.50
Surcharges:	
No Tax Costs:	
GST	122.78
Total Due:	2,578.28

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471
G.S.T. # 881565899 RT0001

DART

Purchase Order

Date Jan 15, 2009	Page 1
Purchase Order Number PO00007977	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAKED
6296115

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 15, 2009	N30	yours	Jan 21, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
24.0000	M174B0250X4000	17-4 SS Bar .250 X 4.00 Comments: MATERIAL: 17-4 PH SS BAR PER AMS 5604/5648 GRAIN MUST BE ALONG LENGTH OF BAR MINIMUM YIELD TENSILE STRENGTH = 100KSI MINIMUM ULTIMATE TENSILE STRENGTH = 150KSI	21/01/2009	No	27.083333	Ft	650.00
12.0000 <i>New 12-7</i>	M303R0313 ✓	303 ROUND BAR .313 Comments: MATERIAL: AISI 303 ROUND BAR (NOTE: AISI 304/316 NOT ACCEPTABLE)	16/01/2009	No	0.791666	f	9.50
✓ 320.0000	M304S16GA	304/316 Sheet .063 Comments: MATERIAL: AISI 304/316 SS SHEET AS PER AMS 5513 OR 5524	21/01/2009	No	5.781250	sf	1.850.00
120.0000	M6061T6B0750X001	6061-T6 Bar .750 x .125 Comments: MATERIAL: 6061-T6 OR 6061-T651/T651/T6510/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4174/4128/4115/4116 PER AMS-QQ-A-200/8 OR AMS 4160	16/01/2009	No	0.416666	f	50.00
192.0000	M6061T6S080	6061-T6 .080 Sheet Comments: MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027	21/01/2009	No	6.145833	sf	1.180.00
* 192.0000	M6061T6S063 ✓	6061-T6 .063 Sheet Comments: AS ABOVE * P.S (REQUIRED MATERIAL FOR FRIDAY THE 16 OF JANUARY) *	16/01/2009	No	3.104166	sf	596.00

Comments:**Tax Summary:**

GST 216.78
ONT PST 0.00

Less:
included tax

0.00

Subtotal

4,335.50

Total tax

216.78

Total purchase order in

CAD Dollars

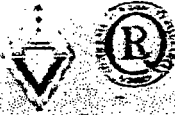
4,552.28

**MATERIAL CERTIFICATION
REQ'D UPON DELIVERY**

Entered By: *CY* CLAVOIE

Approved By: *IN*

Acciaierie Valbruna S.p.A.



CERTIFICATO DI COLLAUDO ABNAHMEPRUEFZEUGNIS INSPECTION CERTIFICATE CERTIFICAT DE RECEPTION EN 10204 (2005) , 3.1

36100 VICENZA (Italia) - Viale dell'Industria 21
Stab.: 39100 BOLZANO (Italia) - Via A. V. 22
Cliente / Besteller/Kunde/Cliant
VALBRUNA CANADA LTD
8724 HOLGATE CRESCENT
CDN-MILTON, ONT L5T 5Z1-CAN

Produttore: ACCIAIERIE VALBRUNA S.P.A.
Hersteller/works/producer

Ass. S. Spedite: D-VI08023633
Certificato di collaudo

Ordine nr. 804001955
Bestellungsnummer

Tipo di Elaborazione: E+AOD
Erzeugnisart/Produktionsverfahren/Mode d'elaboration

Certificato nr: MEST668292/2008/
Prüfung/Test/Exam

Conferma ordine nr: EI08003212
Werkz./Order/Ref. nr.

Marchio di Fabbrica:
Zeichen des Unternehmens
Trade mark
Sigla de l'usine: production

Punzone del Collaudatore:
Stempel des Werkssachverständigen
Inspector's stamp/Stampon de l'essayeur



Oggetto Prove: - Annealed Cold Drawn
Prüfungsbefund/Exam. Inspection/Prüfung

Specifiche:
Anforderungen / Requirements / Exigences
VAL CANADA 2 303 A.C.F.
ASTM A314 97 S30300
DOD-F-24869 6 S30300
(b) SEC. II P.T.A 2007 EDRIC-2

AWS 5640 U TYPE1
ASTM A320 2008 B8F
LHL-S-662 B/1 303

ASME SA320 2007 B8F (b)
ASTM A582 2005 S30300
QQ-S-764 B/2 303

OK

Qualità: T-303
Werkstoff/Grade/Matériau

Marca: VPAU188Z VALPLUS
Markenbezeichnung/Brand/Châssis

Punzonatura: T-303
Kennzeichnung/Härtungsbezeichnung

Pos. nr. Pos. nr. Nr. de poste	Oggetto Gegenstand Product d'accolade Description de produit	Dimensioni Dimensions Dimensions	Tolleranza Tolérance Tolérance	Lunghezza - R Länge Length Longueur	Colata Schmelze Melt Coulée	Pezzi Stückzahl Pieces	Peso - LB Gewicht Weight Poids	Lotto nr. Losch. Lot nr. Lot nr.
0010	Round	0,3125	484-06B	13 / 13	422176		17,320	810205730

Sono state soddisfatte tutte le condizioni richieste
Die geforderten Anforderungen sind erfüllt
The material has been fabricated in accordance with the requirements
Le matériel a été fabriqué conformément aux exigences

Controllo antiradiazioni: OK
Verschleißprüfung: spektroskopisch durchgeführt
Antiradiation testing performed: OK
Contrôle antiradiation: satisfaisant

Controllo visivo e dimensionale: soddisfatta la esigenza:
Bausichtprüfung und Ausmessung: ohne Beanstandung
Visual inspection and dimensional check: satisfactory
Contrôle visuel et dimensionnel: satisfaisant

TEST	Prove Essai Prüfung Test Versuch Prüfung Test Versuch	Temperatura Temperatur Temperature Temperatur	Snervamento Zugversuch Tensile strength Zugversuch Tensile strength	Resistenza Zugfestigkeit Tensile strength Zugfestigkeit Tensile strength	Allungamento Zugdehnung Elongation Zugdehnung Elongation	Strizione Zugversuch Reduction of area Zugversuch Reduction of area	Resilienza Härteprüfung Impact Value Härteprüfung	Durezza Härte Hardness Härte
Valori richiesti 1 Anforderungen/Requisiten values Valeurs demandées	min max		Rp 0,2% k.s.l.	Rm k.s.l.	E 4d %	RA %		HB
A	7,93	68	87	114	38	53		239

1) L - lunghezza della linga; O - diametro della linga; T - temperatura di trattamento

Analisi chimica

Chemische Zusammensetzung/Chemical Analysis/Analyse chimique

Colata Schmelze Coulée	min max	0,150	1,00	2,00	17,00 18,00	0,60	1,00	8,00 10,00	0,15 0,40						
422176	C %	0,045	0,39	1,85	17,39	0,47	0,59	8,05	0,067	0,03	0,30				

Produced without class I-II Ozone depleting substances.

Solution heat treated free from continuous carbide network.

Annealing temperature: 1940°F for 0.5 h/water.

Micro and macro etch test: OK

Material is DFARS Compliant

Melted and manufactured in Italy No welding or weld repair Material free from Mercury or radio-activity contamination
The Quality Management System is Certified acc. Pressure Equipment Directive [97/23/EC] Annex 1, 4.3 by TÜV and LLOYD'S

Vicenza, 11/09/08 VCO008 (Mod. MCER)	Il collaudatore di stabilimento / der Werkssachverständige / Works inspector / L'agent d'usine M. Rizzotto	Pagina - 1 di 1
--	---	-----------------